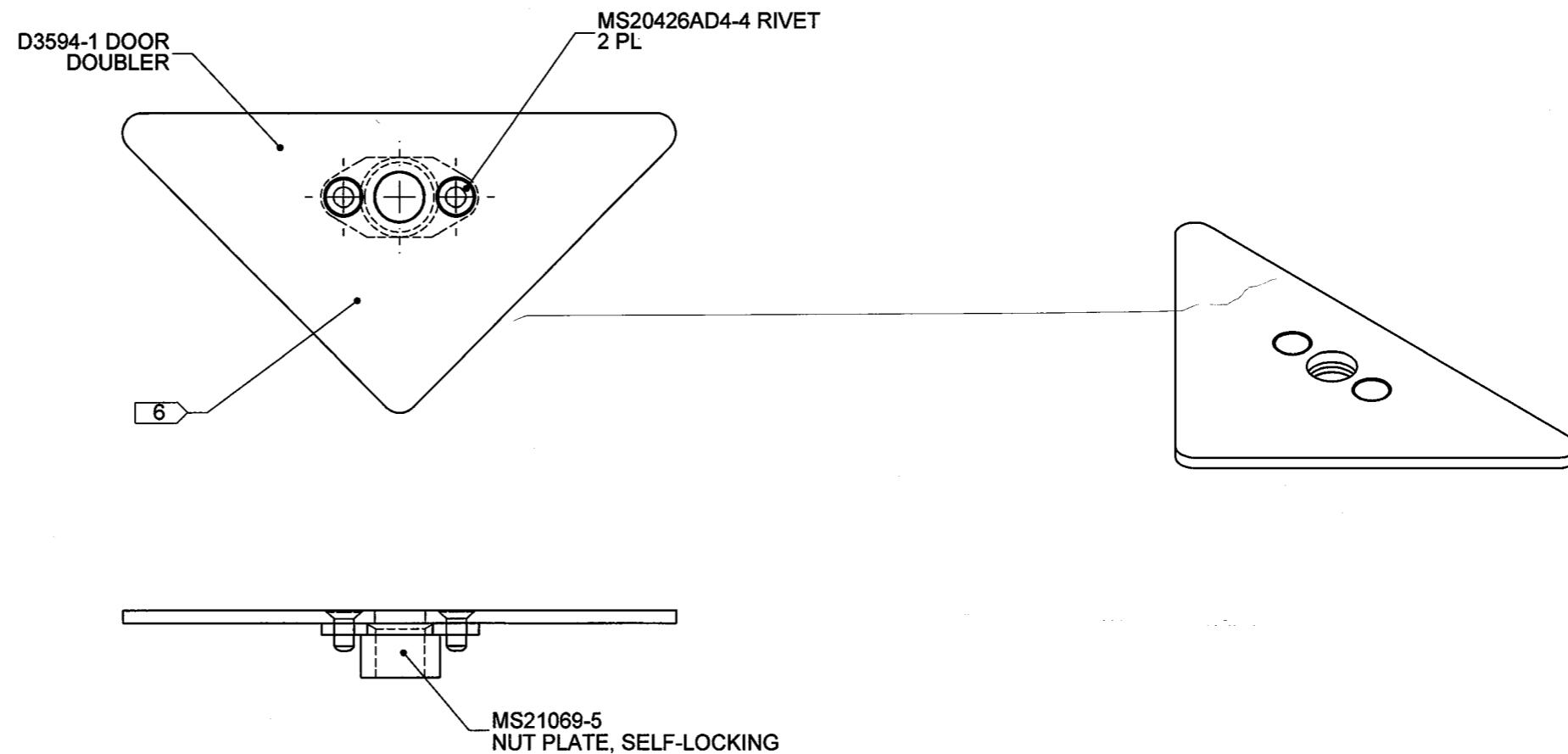


ITEM	QTY -041	P/N	DESCRIPTION
	X	D3594-041	DOUBLER ASSEMBLY
1	1	D3594-1	DOUBLER
2	1	MS21069-5	NUT PLATE, SELF-LOCKING
3	2	MS20426AD4-4	RIVET, SOLID, CSK



### D3594-041 DOOR DOUBLER ASSEMBLY

**RELEASED**

2020 APR 29  
ECN 2020-548

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
  - 7) WEIGHT: 0.04 lbs

APPROVED

E	ADDED D3594-7 AND D3594-047, AND REORGANIZED SHEET ORDER, REASON CAR20-368		SAD	20.04.02
D	MS21069-5 WAS MS21068L3 (ZN D6-1, B3-1, D6-3, D3-3, C5-3, C4-3). REF PAR16-557		VS	17.04.07
C	REFORMAT TO CURRENT STANDARDS. ADD 0.5" OF MATERIAL TO -3 & -4 REASON PAR16-501.		AJS	16.05.25
B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.		AJS	08.05.14
A	NEW ISSUE		MB	07.04.13
REV.	DESCRIPTION		BY	DATE
DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	SAD	DRAWING NO. <b>D3594</b>		
CHECKED	MB	REV. E		
MFG. APPR.	DD	SHEET 1 OF 6		
APPROVED	VS	TITLE <b>DOUBLER</b>		
DE APPR.	DS	SCALE NTS		
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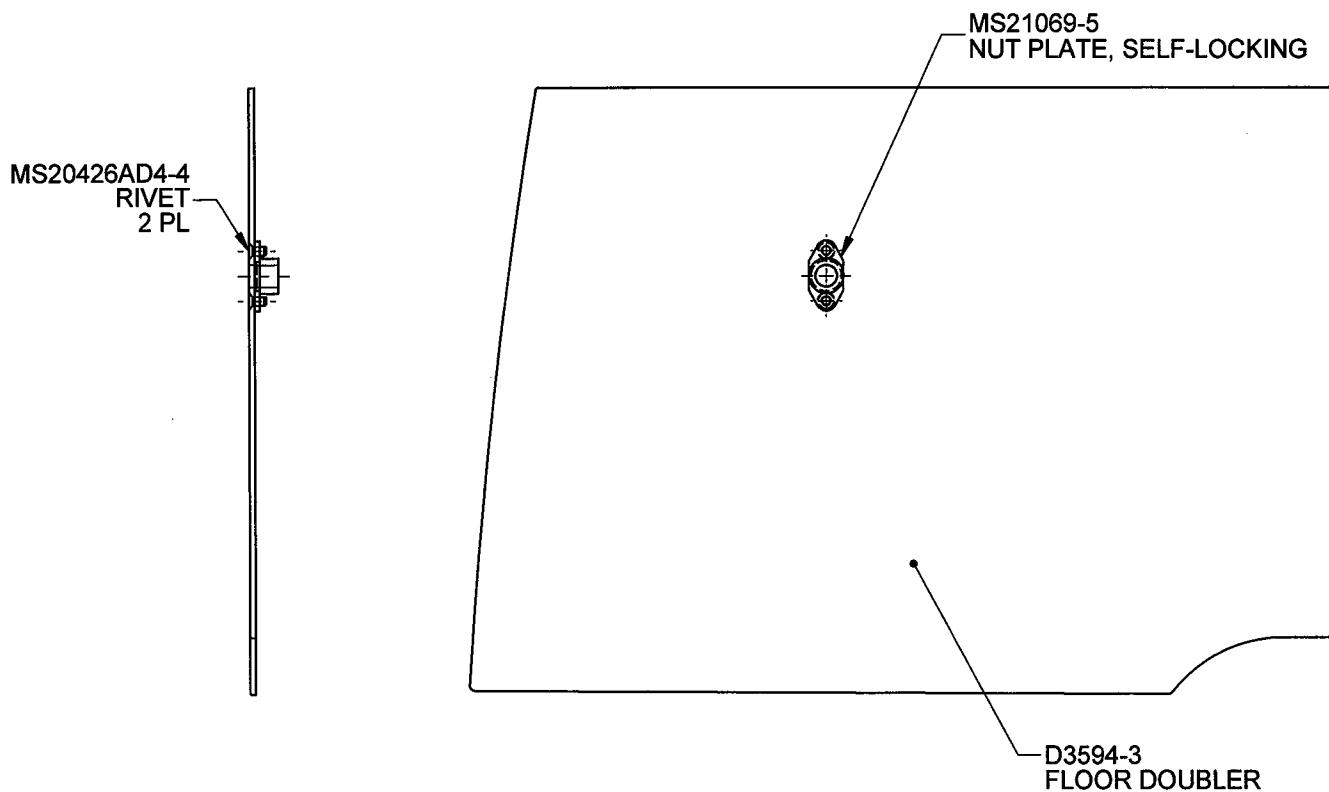
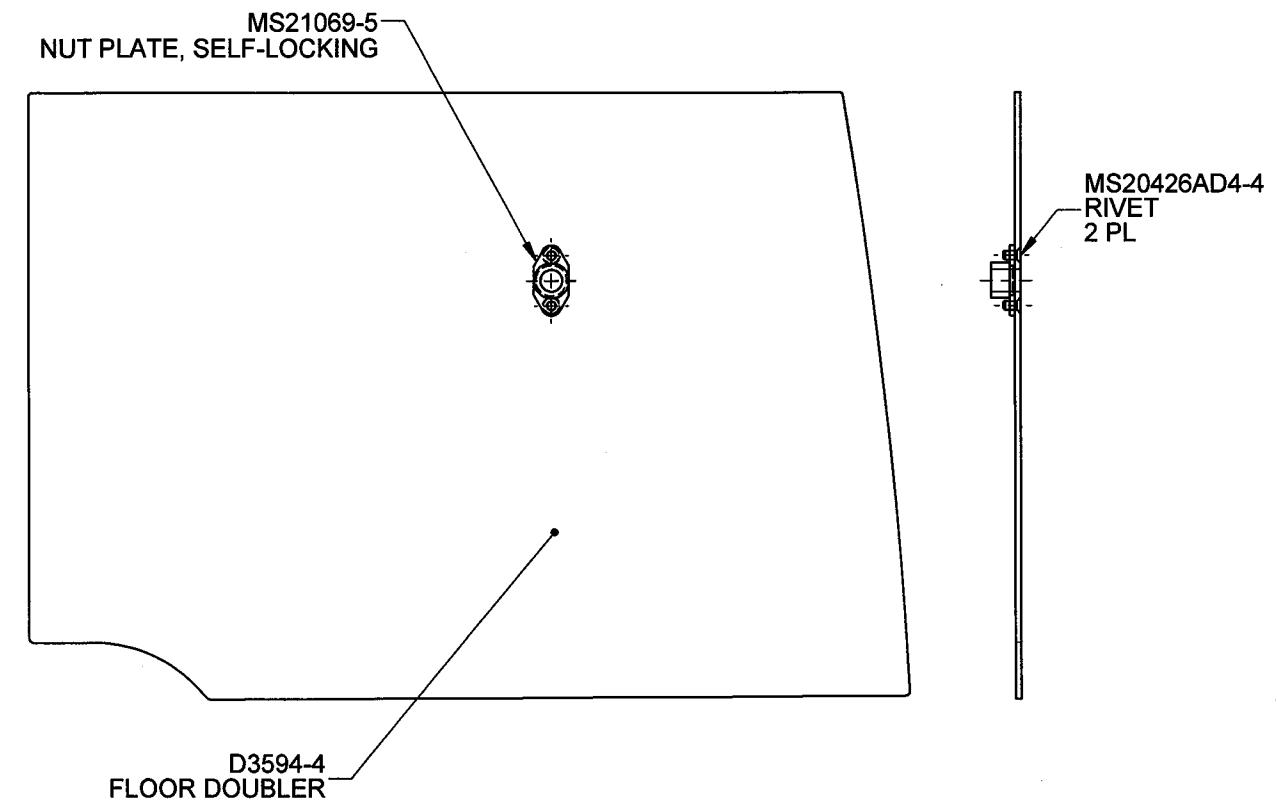
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D3594-043	FLOOR DOUBLER ASSEMBLY
1	1	D3594-3	DOOR DOUBLER ASSEMBLY
2	2	MS20426AD4-4	RIVET, SOLID, CSK
3	1	MS21069-5	NUT PLATE, SELF-LOCKING

ITEM	QTY -044	P/N	DESCRIPTION
	X	D3594-044	FLOOR DOUBLER ASSEMBLY
1	1	D3594-4	DOOR DOUBLER ASSEMBLY
2	2	MS20426AD4-4	RIVET, SOLID, CSK
3	1	MS21069-5	NUT PLATE, SELF-LOCKING

**D3594-043 FLOOR DOUBLER ASSEMBLY****D3594-044 FLOOR DOUBLER ASSEMBLY**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
  - 7) WEIGHT: 0.82 lbs

**RELEASED**

2020 APR 29 47

**APPROVED**

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	SAD	HAWKSLEY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	
MFG. APPR.	DD	REV. E	
APPROVED	VS	D3594	
DE APPR.	DS	SHEET 2 OF 6	
DATE	20.04.02	TITLE	DOUBLER
		SCALE	NTS

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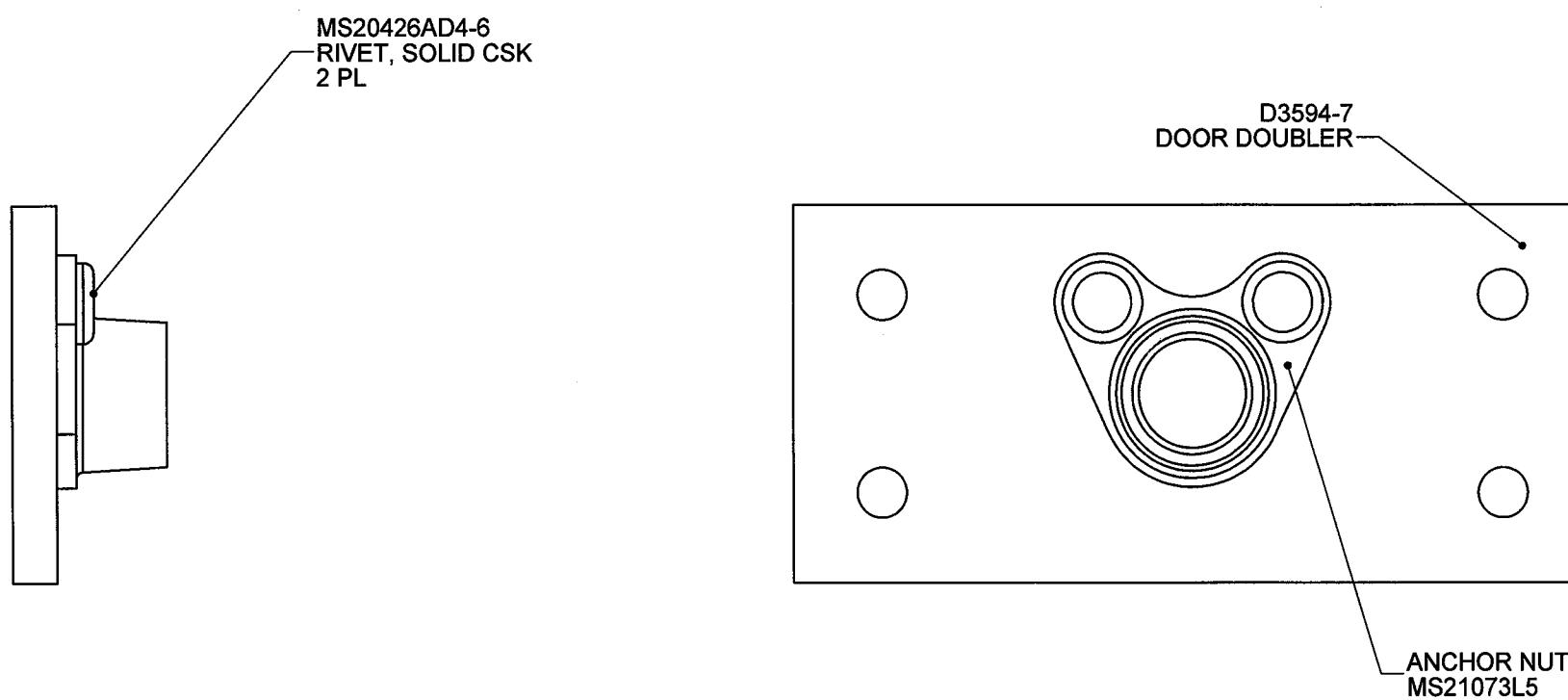
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ITEM	QTY	P/N	DESCRIPTION
	X	D3594-047	DOOR DOUBLER ASSY
1	1	Figure 2 DSI 9847	DOOR DOUBLER
2	1	MS21073L5	ANCHOR NUT
3	2	MS20426AD4-6	RIVET, SOLID, CSK



D3594-047 DOOR DOUBLER ASSEMBLY

E

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
  - 7) WEIGHT: 0.82 lbs

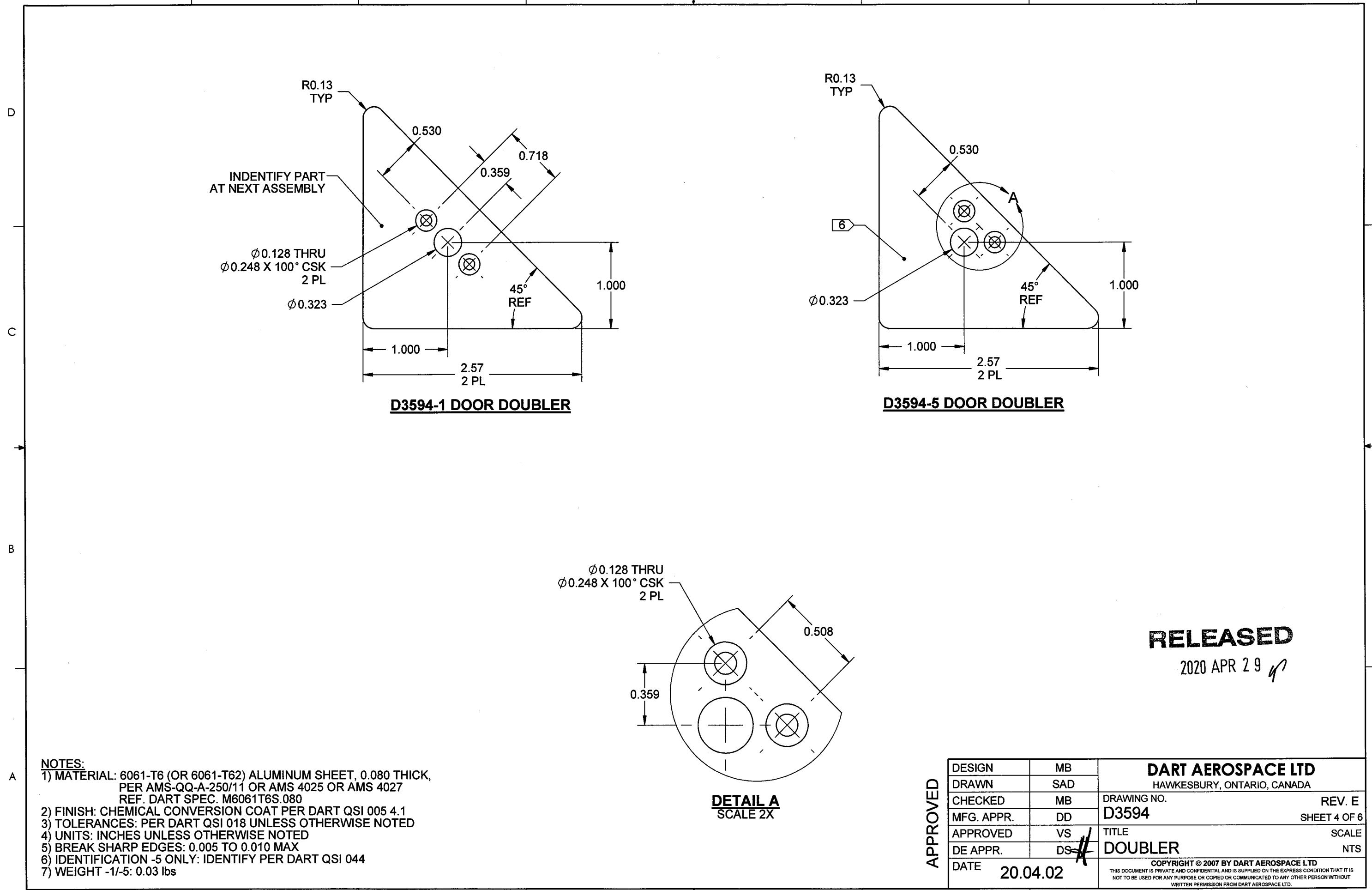
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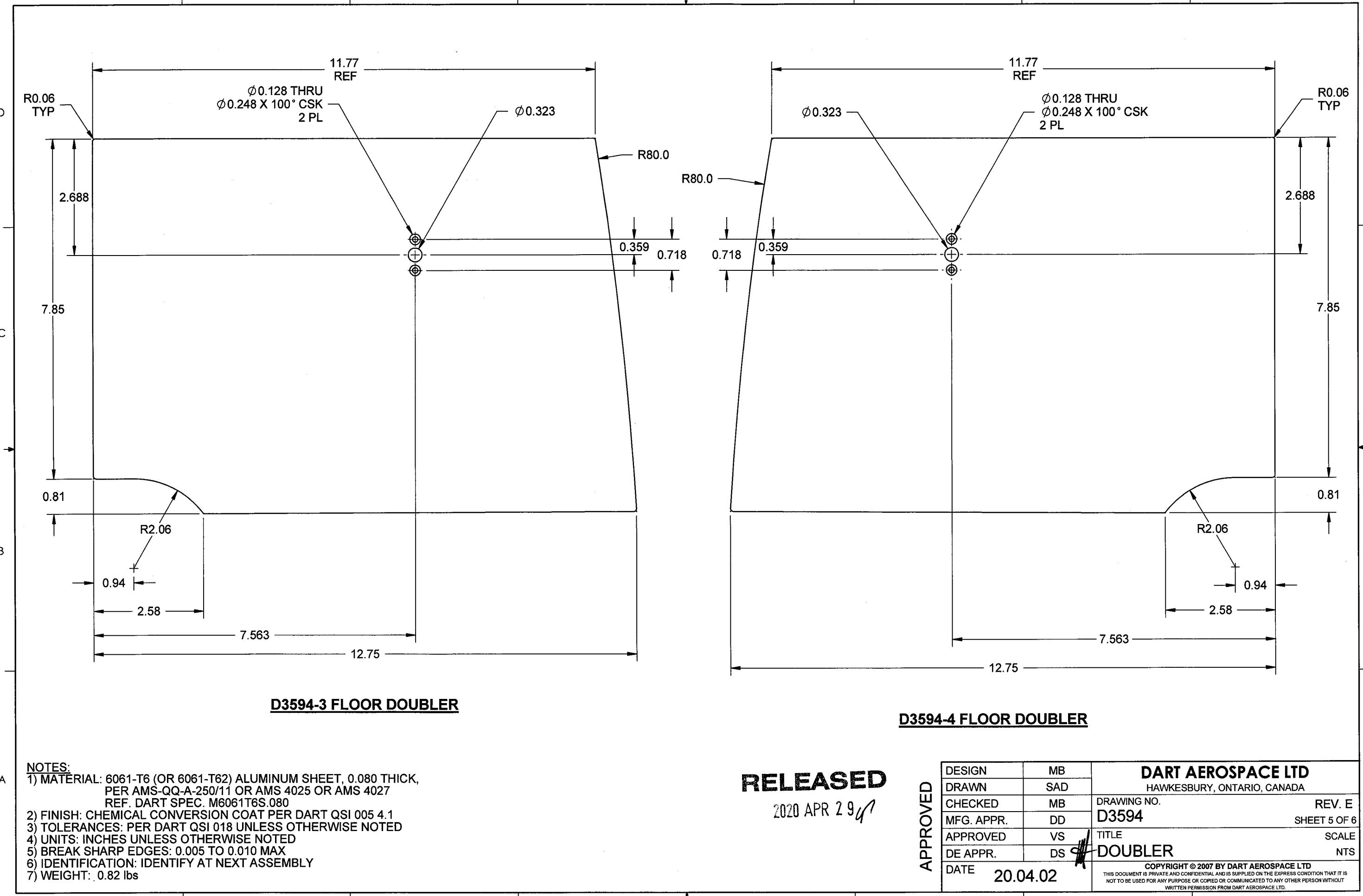
2020 APR 29

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DESIGN	MB	DART AEROSPACE LTD			
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA			
CHECKED	MB	DRAWING NO.			
MFG. APPR.	DD	REV. E			
APPROVED	VS	D3594			
DE APPR.	DS	SHEET 3 OF 6			
DATE	20.04.02	TITLE	SCALE		
		DOUBLER			
NTS					
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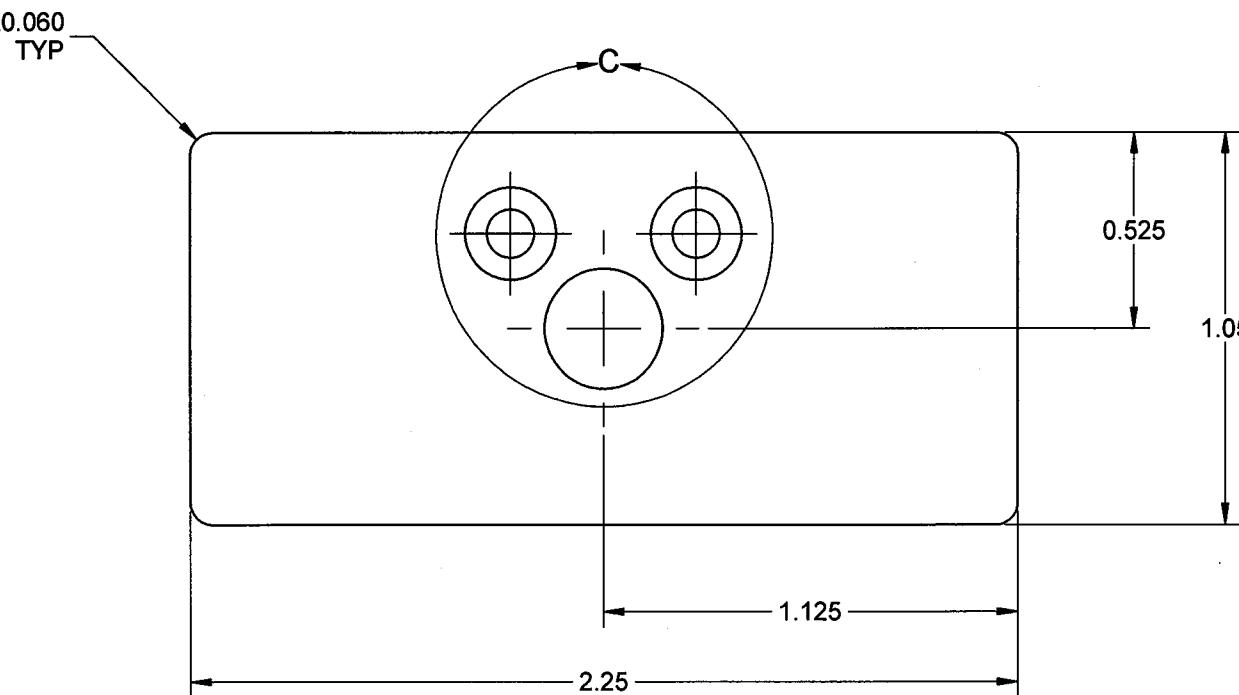
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8 7 6 5 4 3 2 1

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- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
  - 7) WEIGHT: 0.03 lbs

D3594-7 DOOR DOUBLER

E

RELEASED

2020 APR 29 47

APPROVED

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	D3594	SHEET 6 OF 6
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
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